



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.1510
Job Sheet 168285



Part No: 647.1510

Job Qty: 4 ea

Part Name: Upper Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 12/1/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D IPP REV: A NEW ISSUE JFS 14/08/19 VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/30/17	0.00	0.00	Start Up Machining		FK 18-1-9
100	Bandsaw	4 pcs		11/30/17	0.00	0.20	Bandsaw1		FK 18-1-9
110	CNC Vertical Machining	4 pcs		12/1/17	0.00	4.60	HAAS 1		FK 18-1-9
120	QC	4 pcs		12/1/17	0.00	0.00	QC2		FK 18-1-9
130	QC	4 pcs		12/1/17	0.00	0.00	QC8		man 18/01/10
140	Outsource	4 pcs		12/1/17			ATG001-VC	Outsource	AT 18/02/17
150	Packaging	4 pcs		12/1/17	0.00	0.00	Packaging2		AT 18/02/17
155	QC	4 pcs		12/1/17	0.00	0.00	QC5		38
180	Packaging	4 pcs		12/1/17	0.00	0.00	Packaging3		DAG 38
190	QC21-SA	4 Ea		12/1/17	0.00	0.00	QC21		21

Part Op 100 - Cut Blank at 22.000" *** ONE BLANK MAKES TWO PARTS***

Descriptions: 110 - 1-Machine per folio FB337 DWG REV: _____ FOLIO REV: _____ 2- deburr and break all sharp edges

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O to ATG : 038200 1- Black Anodize as per Dwg 647.1500 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required

150 - Receive & Inspect for Damage & Mat'l Certs

155 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location: _____ ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - QC21- Final Inspection - Work Order Release

JAN 17 2017

FEB 0 8 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6S0.375X6.000	4	0	0	0

Part Specifications

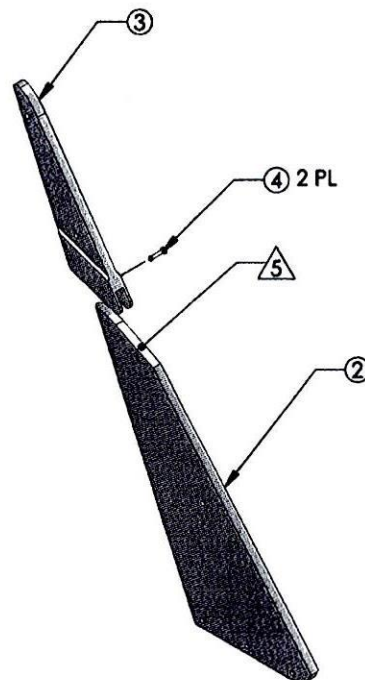
Specifications could not be found.

Plex 11/14/17 7:41 AM dart.boucher.sylvie

Work Order update only

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev

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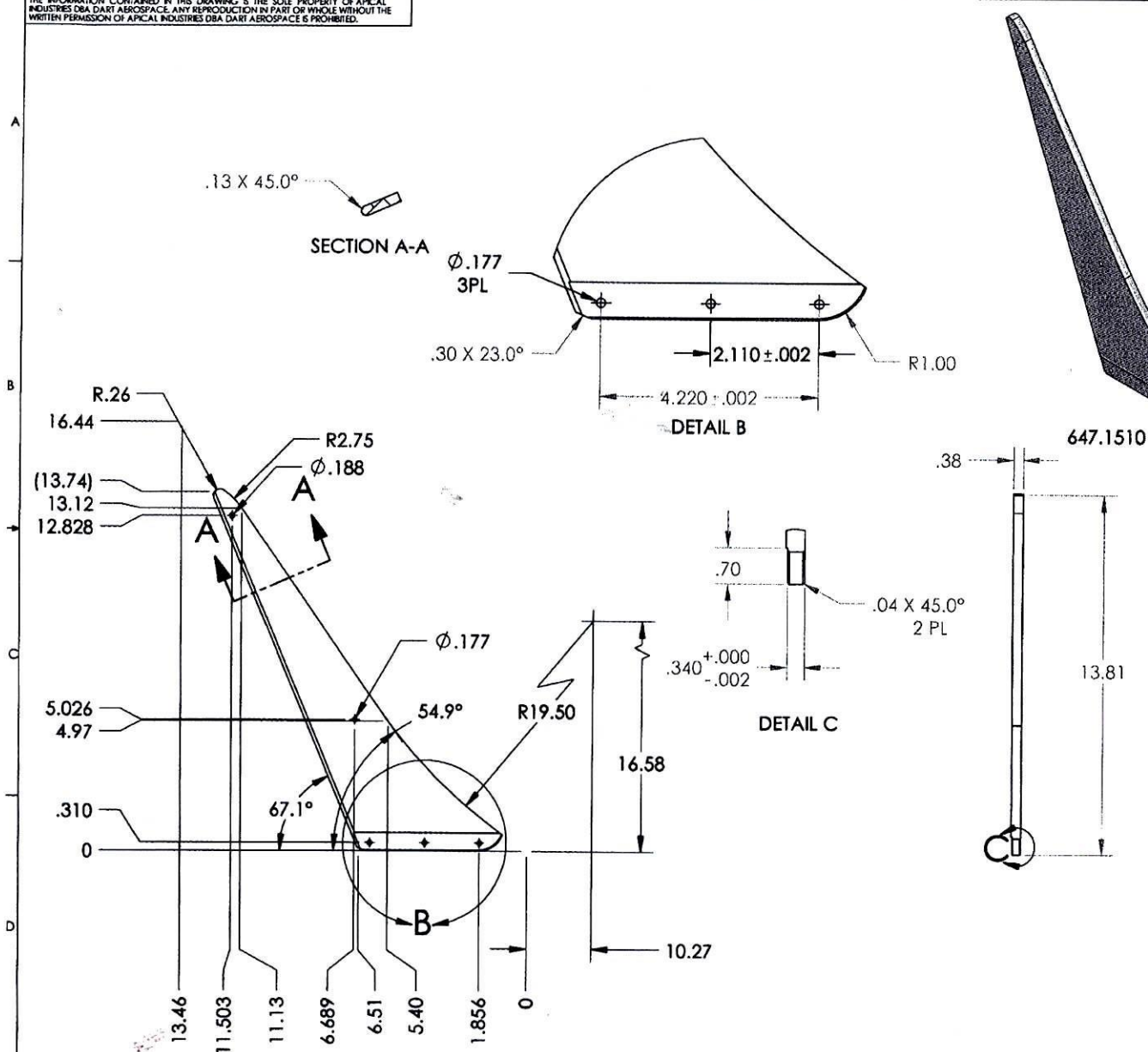


647.1501 SHOWN EXPLODED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168285

ORIGINAL DATE 04-10-07		DART AEROSPACE 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY J. GARDNER		CHECKED P. BRAVO	
DRAWING APPROVAL P. BRAVO		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REV. (CAGE CODE) B 07M26	QWG. NO. 647.1500
SCALE NONE		REV. D SHEET 2 OF 7	

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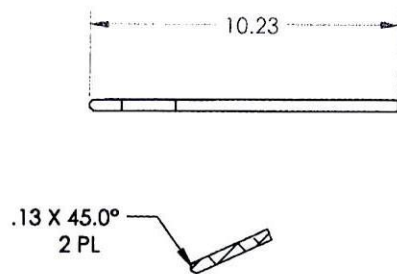
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PRI		N/C
N/C	INITIAL RELEASE	04/10/09	P. BRANCO
A	INCORPORATED ECH 0290, 0474, 0473	11/17/14	P. BRANCO
B	INCORPORATED ECH 05331	03/27/16	P. BRANCO
C	INCORPORATED ECH 05344	02/15/16	P. BRANCO
D	INCORPORATED ECH 05551	11/01/16	P. BRANCO

NOTES:

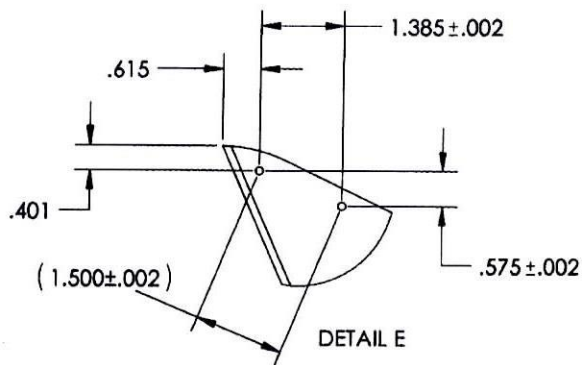
- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH PER MPP-172 SECTION 2.1, 3.3 & 4.3, 1-2 MIL MAX
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120
- 5 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 & 3 UPON ASSY
- 6 MAKE FROM 647.1513

[illegible]

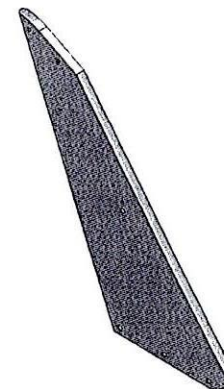
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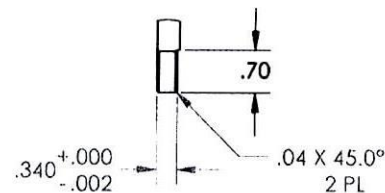
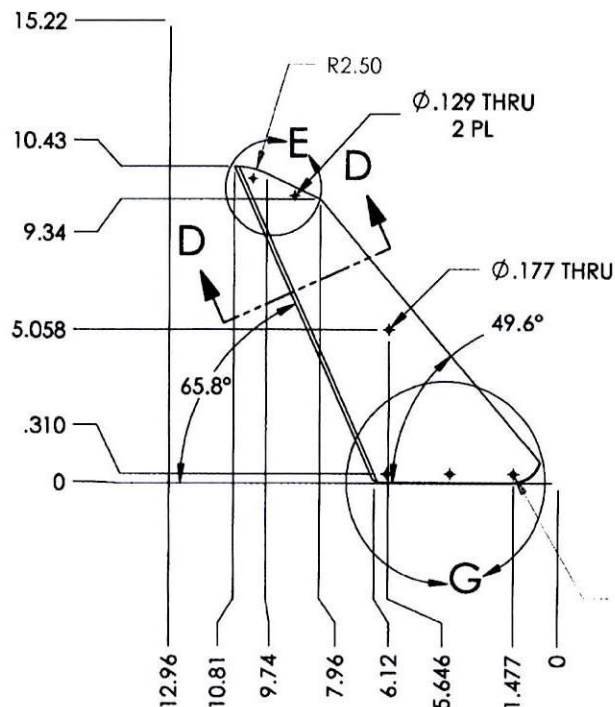
SECTION D-D



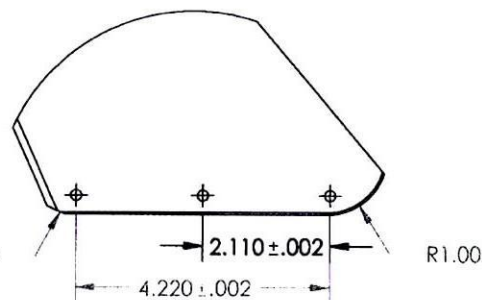
DETAIL E



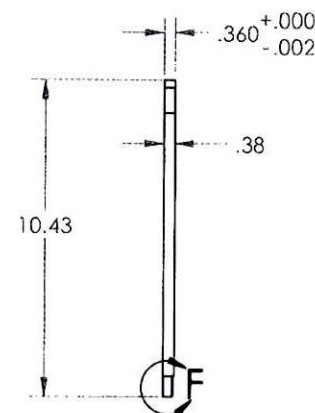
647.1511



DETAIL F



DETAIL G

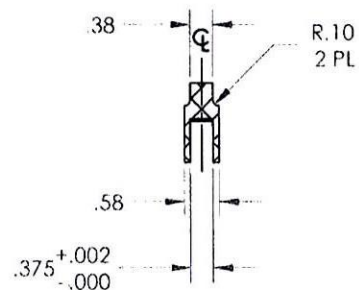
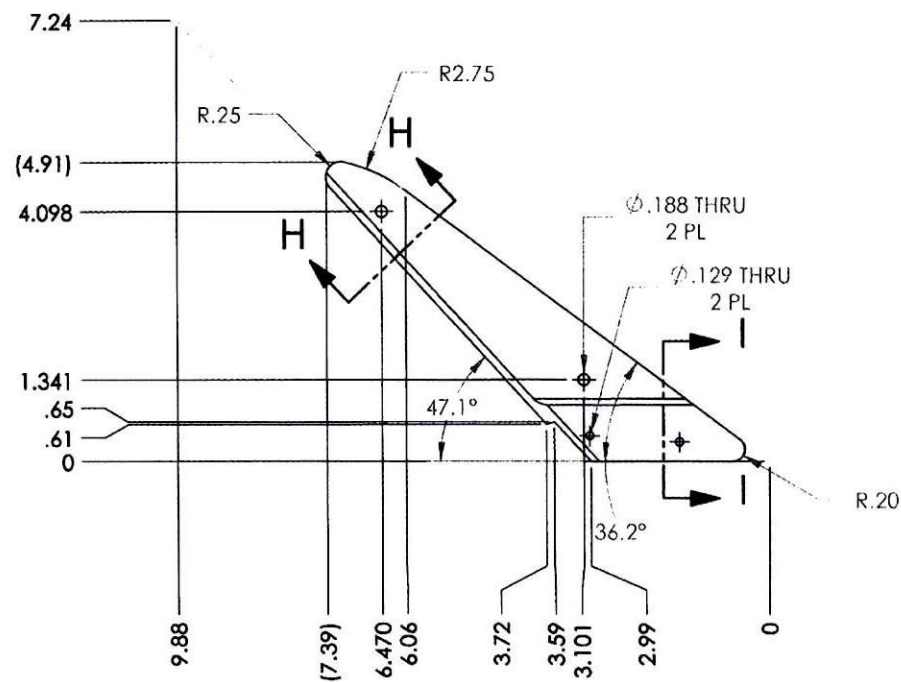


ORIGINAL DATE 11/02/09		04-1009	
DRAWN BY J. GARDNER	CHECKED BY P. BRAY	DART AEROSPACE	
DRAWING APPROVAL P. BRAY	APICAL INDUSTRIES, INC.	3030 ENTERPRISE CT., SUITE A	
CONTRACT NO.	647.1500	VISTA, CA 92081	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 ANGLES ± .5°		DEFLECTORS	
SHEET 8	CAGE CODE 07M26	DWG. NO. 647.1500	REV. D
SCALE NONE		SHEET 3 OF 7	

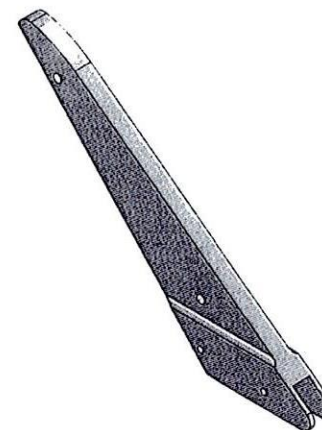
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.13 X 45.0°
2 PL

SECTION H-H



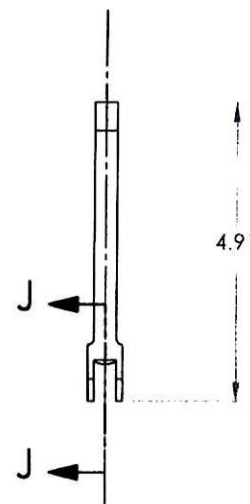
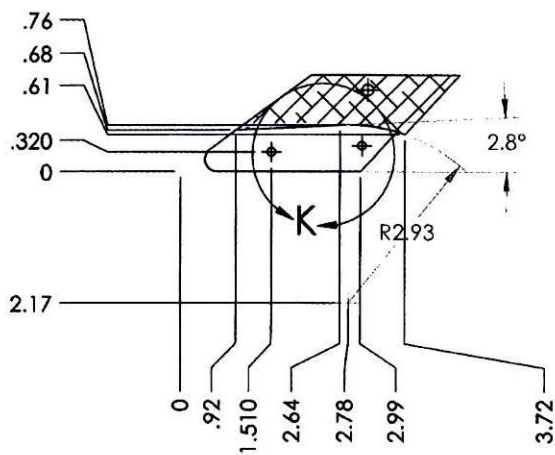
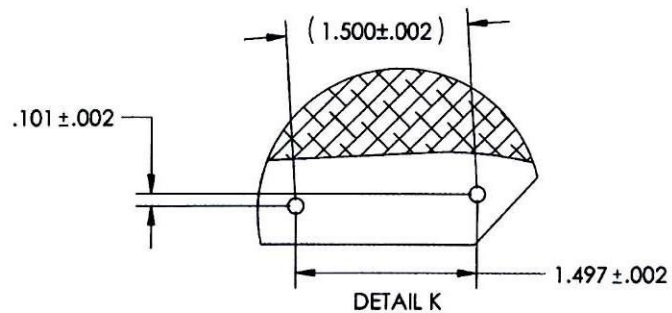
SECTION I-I



647.1512

ORIGINAL DATE (JMO-CM-17)	06-10-09	 DART AEROSPACE APICAL INDUSTRIES INC. DBA DART AEROSPACE	3030 ENTERPRISE CT. SUITE A VISTA, CA. 92081 (760)-724-5300
DRAWN BY J. GARDNER	CHECKED BY P. BRAVO		
DRAWING APPROVAL P. BRAVO	DATE 06-10-09		
CONTRACT NO.			
DEFLECTORS			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B CAGE CODE 07M26 DWG. NO. 647.1500 SCALE NONE	REV. D SHEET 4 OF 7

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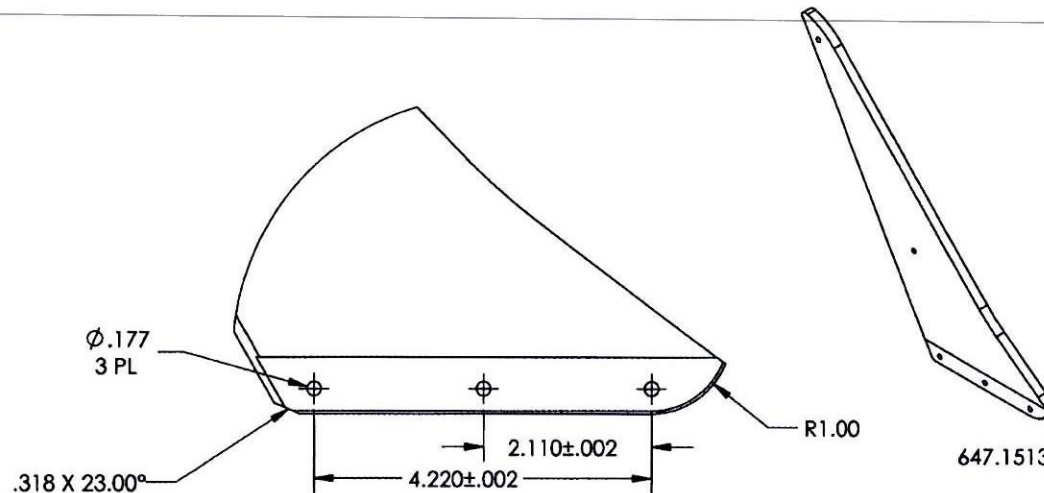
647.1512 RIGHT VIEW

ORIGINAL DATE 10/03/09		CA-1009	
DRAWN BY J. GARDNER		CHECKED P. BRAVO	
DRAWING APPROVAL A. BRAVO		APICAL INDUSTRIES, INC. (DBA DART AEROSPACE)	
CONTRACT NO.		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5°		DEFLECTORS	
SEE 8	CAGE CODE 07M26	DWG. NO. 647.1500	REV. D
SCALE NONE		SHEET 5 OF 7	

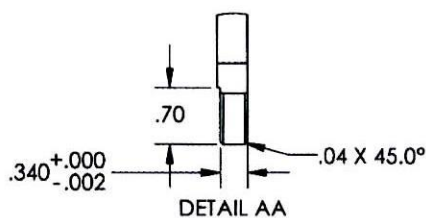
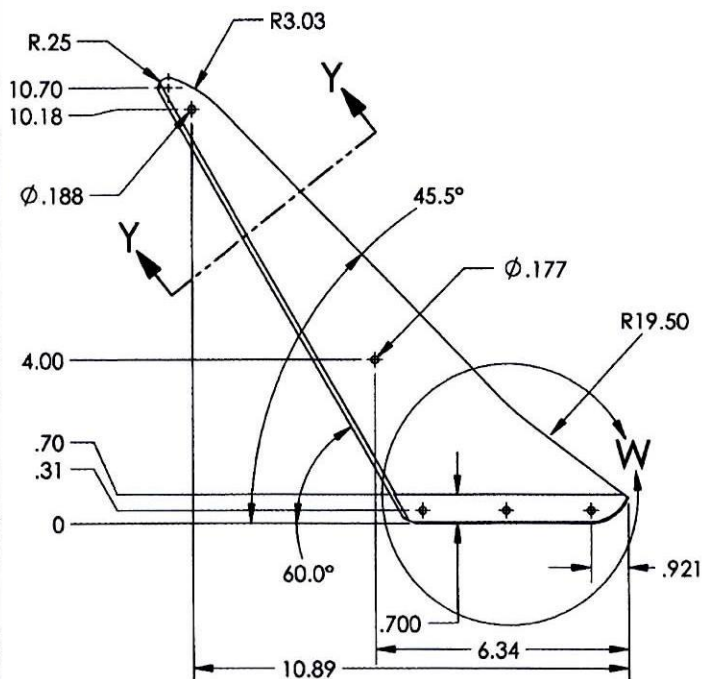
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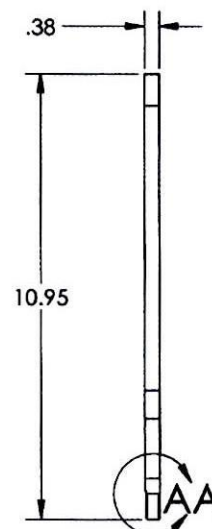
SECTION Y-Y



DETAIL W



DETAIL AA

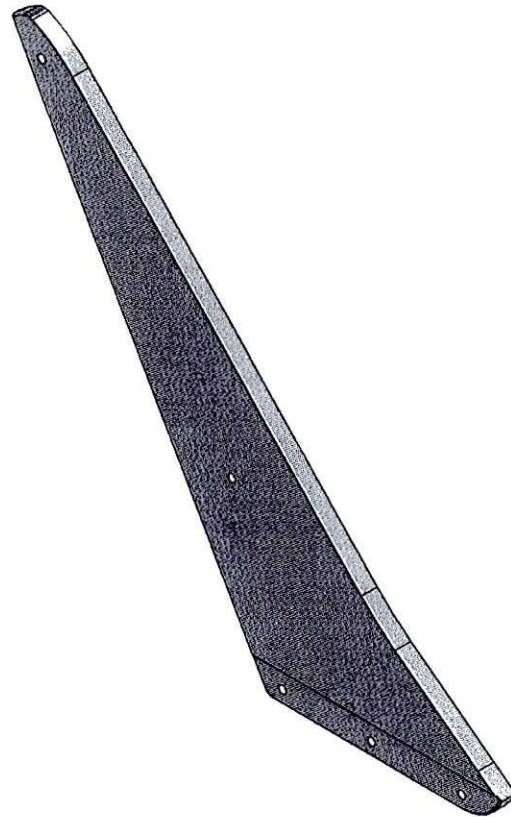


ORIGINAL DATE 2/20/06-1/19		06-10-09	
DRAWN BY J. GARDNER		CHECKED P. BRAVO	
DRAWING APPROVAL P. BRAVO		06-10-09	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.3°			
S28	CAGE CODE 8	DWG. NO. 07M16	REV. D
SCALE NONE		SHEET 6 OF 7	

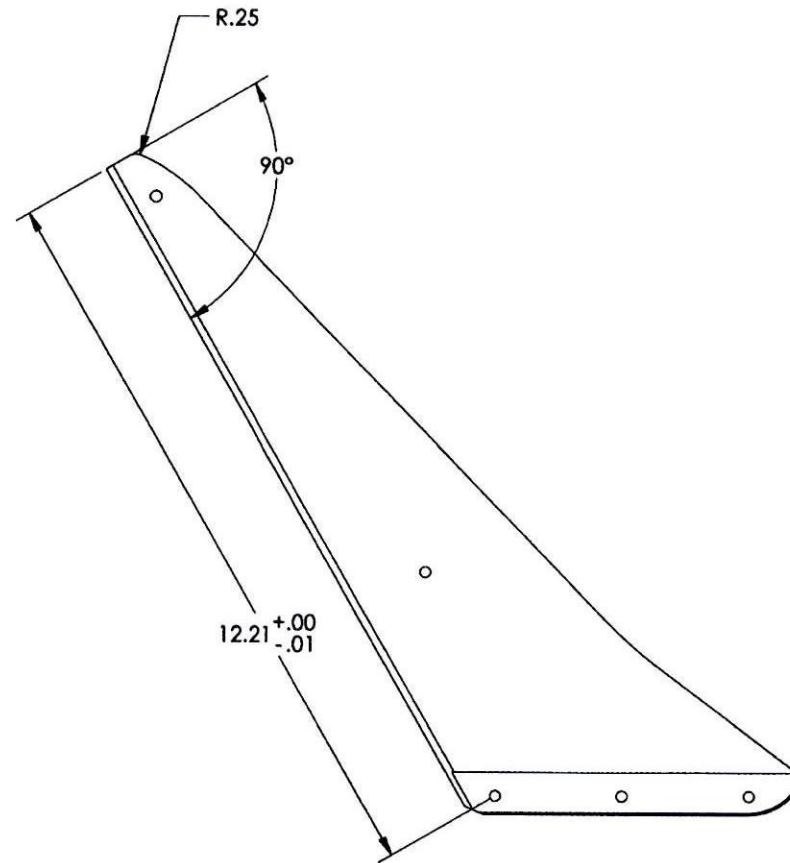
DART 3030 ENTERPRISE CT.,
AEROSPACE SUITE A
VISTA, CA 92081
APICAL INDUSTRIES, INC.
(760)-724-5300
DEFLECTORS

1 2 3 4 5 6 7 8

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647.1514 



ORIGINAL DATE (MCO-DAT) 06-10-09	 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300 APICAL INDUSTRIES, INC. DBA DART AEROSPACE					
DRAWN BY J. GARDNER				P. BRAVO		
DRAWING APPROVAL P. BRAVO (MCO-DAT) 06-10-09						
CONTRACT No.		DEFLECTORS				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE	CAGE CODE	DWG. NO.	REV.	
		B	07M26	647.1500	D	
		SCALE NONE				SHEET 7 OF 7



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038802

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038802
PO Date: 1/17/18
Due Date: 1/31/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
JAN 30 2018

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170136	D2348	Wearplate (Key Way) Issue P/O: Black Anodize per Dwg D2348 Rev. C	Firmed	1/31/18	20 pcs	0 pcs	20 pcs	\$5.76/pcs	\$115.20
Line Item Note RUSH!!!!										
2	169475	647.7811	Bracket B Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	1/31/18	10 pcs	0 pcs	10 pcs	\$15.63/pcs	\$156.30
Line Item Note RUSH!!!!										
3	170172	647.7812	Center Plate, Upper Issue P/O to ATG : Hard Black Anodize and Prime Dwg 647.7800 Rev. A	Firmed	1/31/18	6 pcs	0 pcs	6 pcs	\$9.88/pcs	\$59.28
Line Item Note RUSH!!!!										
4	168218	646.3011	RH Half Issue P/O to ATG : Hard Black Anodize, Color Black and Prime as Per Dwg 646.3000	Firmed	1/31/18	10 pcs	0 pcs	10 pcs	\$11.38/pcs	\$113.80
Line Item Note RUSH!!!!										
5	168219	646.3012	Lower Guide Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed	1/31/18	10 pcs	0 pcs	10 pcs	\$21.03/pcs	\$210.30
Line Item Note RUSH!!!!										
6	168217	646.3010		Firmed	1/31/18	6 pcs	0 pcs	6 pcs	\$11.38/pcs	\$68.28

Plex 1/30/18 8:45 AM dart.baker.diane



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038802

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	168018	646.3011	LH Half Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.3000 RH Half Issue P/O to ATG : Hard Black Anodize, Color Black and Prime as Per Dwg 646.3000	Firmed	1/31/18	4 pcs	0 pcs 4x	4 pcs AT	\$11.38/pcs (8/2/07)	\$45.52
8	168241	646.3711	Clip Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.3700 Rev. A	Firmed	1/31/18	12 pcs	0 pcs 12x	12 pcs AT	\$7.23/pcs (8/2/07)	\$86.76
9	168242	646.3712	Clip Issue P/O to ATG : Hard Anodize, Color Black and Prime as Per Dwg 646.3712 Rev. A	Firmed	1/31/18	12 pcs	0 pcs 12x	12 pcs AT	\$7.23/pcs (8/2/07)	\$86.76
10	168243	646.3713	Gusset Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed	1/31/18	10 pcs	0 pcs 10x	10 pcs AT	\$16.88/pcs (8/2/07)	\$168.80
11	168244	646.3714	Gusset Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700 Rev. A	Firmed	1/31/18	12 pcs	0 pcs 12x	12 pcs AT	\$16.88/pcs (8/2/07)	\$202.56
12	169366	646.9810	Deflector Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.9800 Rev. A	Firmed	1/31/18	10 pcs	0 pcs	10 pcs	\$48.38/pcs	\$483.80
13	168275	647.0113	Strut Doubler Issue P/O to ATG : Hard anodize, Color Black and Prime as Per Dwg 647.0100 Rev. A	Firmed	1/31/18	15 pcs	0 pcs 15x	15 pcs AT	\$12.88/pcs (8/2/07)	\$193.20
14	168285	647.1510	Upper Deflector Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.1500 Rev. D	Firmed	1/31/18	4 pcs	0 pcs 4x	4 pcs AT	\$21.78/pcs (8/2/07)	\$87.12
15	168293	647.1713	Spacer Issue P/O to ATG :	Firmed	1/31/18	20 pcs	0 pcs 20x	20 pcs AT	\$5.38/pcs (8/2/07)	\$107.60



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PURCHASE ORDER PO038802

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
16	169481	647.1714	Hard Black Anodize and Prime as per Dwg. 647.1700 Rev. E Plate Issue P/O to ATG :	Firmed	1/31/18	10 pcs	0 pcs	10 pcs	\$31.38/pcs	\$313.80
17	169482	647.1715	Hard Anodize and Prime as Per Dwg 647.1700 Rev. E Plate Issue P/O to ATG :	Firmed	1/31/18	10 pcs	0 pcs	10 pcs	\$31.38/pcs	\$313.80
18	169479	647.7816	Hard Black Anodize and Prime as per Dwg 647.1700 Rev. E Aft Bracket Issue P/O to ATG :	Firmed	1/31/18	10 pcs	0 pcs	10 pcs	\$7.98/pcs	\$79.80
19	169480	647.7817	Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A Aft Bracket Issue P/O to ATG :	Firmed	1/31/18	6 pcs	0 pcs	6 pcs	\$7.98/pcs	\$47.88
20	169484	647.7611	Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A Lower Deflector Issue P/O to ATG :	Firmed	1/31/18	6 pcs	0 pcs	6 pcs	\$13.18/pcs	\$79.08
21	169474	647.7810	Hard Black Anodize and Prime as per Dwg 647.7600 Bracket A Issue P/O to ATG :	Firmed	1/31/18	4 pcs	0 pcs	4 pcs	\$12.03/pcs	\$48.12
22	169476	647.7813	Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A Center Plate, Lower Issue P/O to ATG :	Firmed	1/31/18	6 pcs	0 pcs	6 pcs	\$9.88/pcs	\$59.28
23	169477	647.7814	Hard Black Anodize and Prime as per Dwg. 647.7800 Rev. A Fwd Bracket Issue P/O to ATG :	Firmed	1/31/18	6 pcs	0 pcs	6 pcs	\$7.98/pcs	\$47.88
24	169478	647.7815	Hard Black Anodize and Prime as per Dwg. 647.7800 Rev. A	Firmed	1/31/18	6 pcs	0 pcs	6 pcs	\$7.98/pcs	\$47.88



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PURCHASE ORDER

PO038802

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
25	168297	647.1817	Fwd Bracket Issue P/O to ATG : Support RH ISSUE P/O: _____ Hard Anodize, Color Black As Per Dwg. 647.1800 Rev. A	Firmed	1/31/18	4 pcs	0 pcs	4 pcs	\$12.63/pcs	\$50.52
26	169392	647.7910	Angle Bracket ISSUE P/O: _____ Hard Anodize, Color Black and Prime as per Dwg. 647.7900 Rev.	Firmed	1/31/18	22 pcs	0 pcs	22 pcs	\$9.13/pcs	\$200.86
27	169393	647.7912	Clip ISSUE P/O: _____ Hard Anodize, Color Black and Prime As Per Dwg. 647.7900	Firmed	1/31/18	8 pcs	0 pcs	8 pcs	\$10.73/pcs	\$85.84
28	169397	647.7916	Bracket ISSUE P/O: _____ Hard Anodize, Color Black and Prime as per Dwg 647.7900	Firmed	1/31/18	10 pcs	0 pcs	10 pcs	\$10.48/pcs	\$104.80
29	169914	SWA6A-800A	Connector Bushing -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL- A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required	Firmed	1/31/18	10 pcs	0 pcs	10 pcs	\$5.88/pcs	\$58.80
30	169929	RBW6405G02131-3G-3	Bell -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL- A-8625F TYPE 2 CLASS 1 Water seal - Certificate of Conformity is required	Firmed	1/31/18	3 pcs	0 pcs	3 pcs	\$5.76/pcs	\$17.28
31	170021	RB877528-4-21	Cap -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2 -Certification of Conformity is required	Firmed	1/31/18	4 pcs	0 pcs	4 pcs	\$5.76/pcs	\$23.04
32	169858	RBD29905-5	Hook -Issue P/O to ATG : PO	Firmed	1/31/18	4 pcs	0 pcs	4 pcs	\$38.63/pcs	\$154.52



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Canada

Tel (613) 632-5200

PURCHASE ORDER PO038802

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			-ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required							
Grand Total:										\$3,918.46

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/30/18 8:45 AM dart.baker.diane



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914586

Date: 06-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
4 ea	Part: 647.1510 Upper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22383		Rev: D PO: PO038802 Line: 14
6 ea	Part: 647.7611 Lower Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22389		Rev: NC PO: PO038802 Line: 20
6 ea	Part: 647.7813 Center Plate, Lower Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22391		Rev: A PO: PO038802 Line: 22
6 ea	Part: 646.3010 LH Half Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22375		Rev: NC PO: PO038802 Line: 6
4 ea	Part: 646.3011 RH Half Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6		Rev: NC
Made in Canada.			

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Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	- .9 mils) per drawing. Job: 22376	PO: PO038802	Line: 7
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>6/2/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			